

T-099 ALERT Service Bulletin

Required Compressor Wheel Inspections

Engine Application(s):	Rolls-Royce (Allison) 250-B17 & C20 Series
Subject:	Compressor Wheel Inspections
Compliance:	Reference Extex Inspection Limits & Repair service document T-021 rev K or later.
Revision History:	NC Dated 12/20/06 Initial Release. A Dated 06/03/08 Added emphasis on 2/3 blades. B Dated 08/07/09 Updated EXTEX to TIMKEN. C Dated 02/08/16 Updated Timken to EXTEX Engineered Products.

NOTE: On 10-20-15, Timken Alcor Aerospace Technologies, Inc. (TAATI) was acquired by Kaman Corporation and renamed EXTEX Engineered Products, Inc.

CAUTION:

Failure to comply with this Alert Service Bulletin may result in engine failure.

TIMKEN has received recent reports of compressor blade separations in 2/3 compressor wheels attributable to corrosion pitting. These events underscore the importance of periodic compressor washing and inspection, particularly when operating in corrosive environments.

All TIMKEN RR250 compressor wheels have been manufactured from "Custom 450" stainless steel since their original FAA approval. While this alloy is more corrosion resistant than the material used by some other manufacturers, it is not impervious to corrosion.

As a reminder, TIMKEN Inspection Limits and Repair document T-021 requires inspection of all compressor wheels operated in corrosive or erosive environments at intervals not to exceed 300 hours or 12 months. This inspection interval corresponds to the compressor case half inspection interval specified in the OEM Maintenance Manual 72-00-00 Table 602 and therefore should not impose a significant burden.

Since this issue has only been associated with the 2/3 wheel, extra attention should be paid when inspecting the 2/3 blade root fillet radius and leading/trailing edges. The presence of corrosion pits is cause for rejection.

PLEASE NOTE: IT IS IMPORTANT TO VERIFY THAT THERE IS NO EVIDENCE OF CORROSION ON THE 2/3 WHEELS. A BORESCOPE OR OTHER INSPECTION EQUIPMENT MAY BE NECESSARY TO COMPLY WITH THIS BULLETIN. IF CORROSION IS PRESENT OR IF IT IS NOT POSSIBLE TO VERIFY CORROSION IS NOT PRESENT Extex STRONGLY RECOMMENDS THAT THE 2/3 COMPRESSOR WHEEL BE REPLACED.

Please contact your Extex Engineered Products representative with any questions.